

Work Order ID 57855

Monday, April 19, 2010 1:47:13 PM



Page 1

Item ID: D4040-1

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 4/19/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-4-19

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D4040 A

100 Cut blanks as per folio

0.00

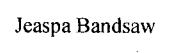
ank 10/04/2012 Ø

Bandsaw

Memo

0.00

CUT BLANK 6.050" LONG



Jeaspa Bandsaw

105

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA890

DWG REV: AFOLIO REV: AAank 10/04/2012 Ø

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57855

Monday, April 19, 2010 1:47:13 PM



Page 2

Item ID: D4040-1

Accept



Setup

Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 4/19/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

and, 10/04/21

12 0

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

SIR 10/04/22

12 0

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

M 10/04/22

12 0

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57855

Monday, April 19, 2010 1:47:13 PM



Page 3

Item ID: D4040-1

Accept



Setup

Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 4/19/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

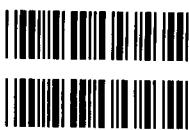
Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

(12)

BK 10-4-22



QC

Quality Control

Memo

0.00

160

Identify as per dwg & Stock Location

10

0.00



Packaging

Packaging

Memo

0.00

10-4-26 8/ 12

170

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/4/27 8/

MF 10-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 1:47:13 PM

Page 1

Work Order ID: 57855



Parent Item: D4040-1



Parent Item Name: Radius Block

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X00.75 0		Purchased		No		100	f	25.2000	1.1368			

6061T6 BAR .375 x .750



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	25.2	
10829	5.2	
113719	20	

1.1368 on 10/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

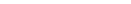
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57855
Description: RADIUS BLOCK	Part Number:	D4040-1
Inspection Dwg: D4040 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10/04/21	Date:	10/04/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

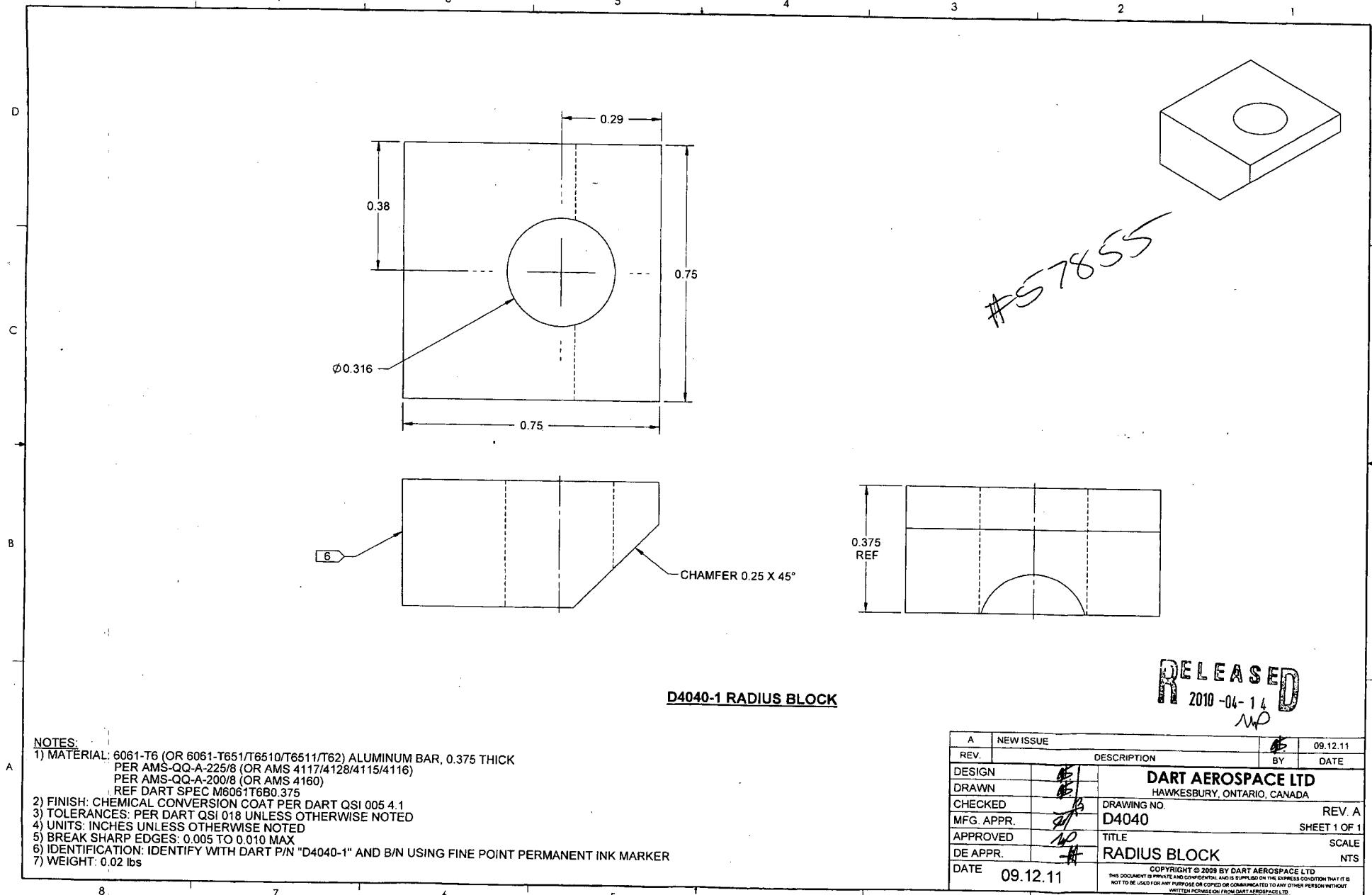


Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

<i>1. Overproduction</i>	<i>2. Rework</i>
<i>3. Transportation</i>	<i>4. Inappropriate / over Processing</i>
<i>5. Unnecessary Inventory</i>	<i>6. Delays / Waiting</i>
<i>7. Unnecessary Motions</i>	



RELEASED 2010-04-14 MP

A NEW ISSUE		09.12.11
REV.	DESCRIPTION	BY DATE
DESIGN	<i>BB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>BB</i>	DRAWING NO. D4040 REV. A
CHECKED	<i>BB</i>	SHEET 1 OF 1
MFG. APPR.	<i>BB</i>	TITLE RADIUS BLOCK SCALE NTS
APPROVED	<i>BB</i>	DATE 09.12.11
DE APPR.	<i>BB</i>	

COPYRIGHT © 2009 BY DART AEROSPACE LTD.
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries